

Date: Thursday, 08/02/2007 9:20:35 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30702
 Estimate Number : 12089
 P.O. Number : *N/A*
 This Issue : 08/02/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 29493
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : est rev A 06.01.23 new issue EC

Drawing Name : HANDLE WELDMENT
 Part Number : D3355041
 Drawing Number : D3355 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : *N/A*
 Due Date : 12/02/2007

Qty: *(2)* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 VA2160 SNAP BUTTON



(2)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 SNAP BUTTON batch: *M17355*

M16372

Cpl 07-02-14

2.0 GP1R Black Vinyl Grip



(2)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Black Vinyl Grip batch: *M16871*

Cpl 07-02-14

3.0 D3355047 ADJUSTABLE EXTENSION



(2)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 ADJUSTABLE EXTENSION batch: *B30720*

Cpl 07-02-14

4.0 D3355045 BOTTOM PART



(2)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 BOTTOM PART batch: *B30719-1*

Cpl 07-02-14

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



(2)

Comment: SMALL & MEDIUM FAB RESOURCE 1
 Assemble as per dwg D3355

Cpl 07-02-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/02/2007 9:20:36 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 30702

Part Number: D3355041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



070214

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51366

070214

8.0

QC21

FINAL INSPECTION W/O RELEASE



2

Comment: FINAL INSPECTION W/O RELEASE

070214

Job Completion



070214

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

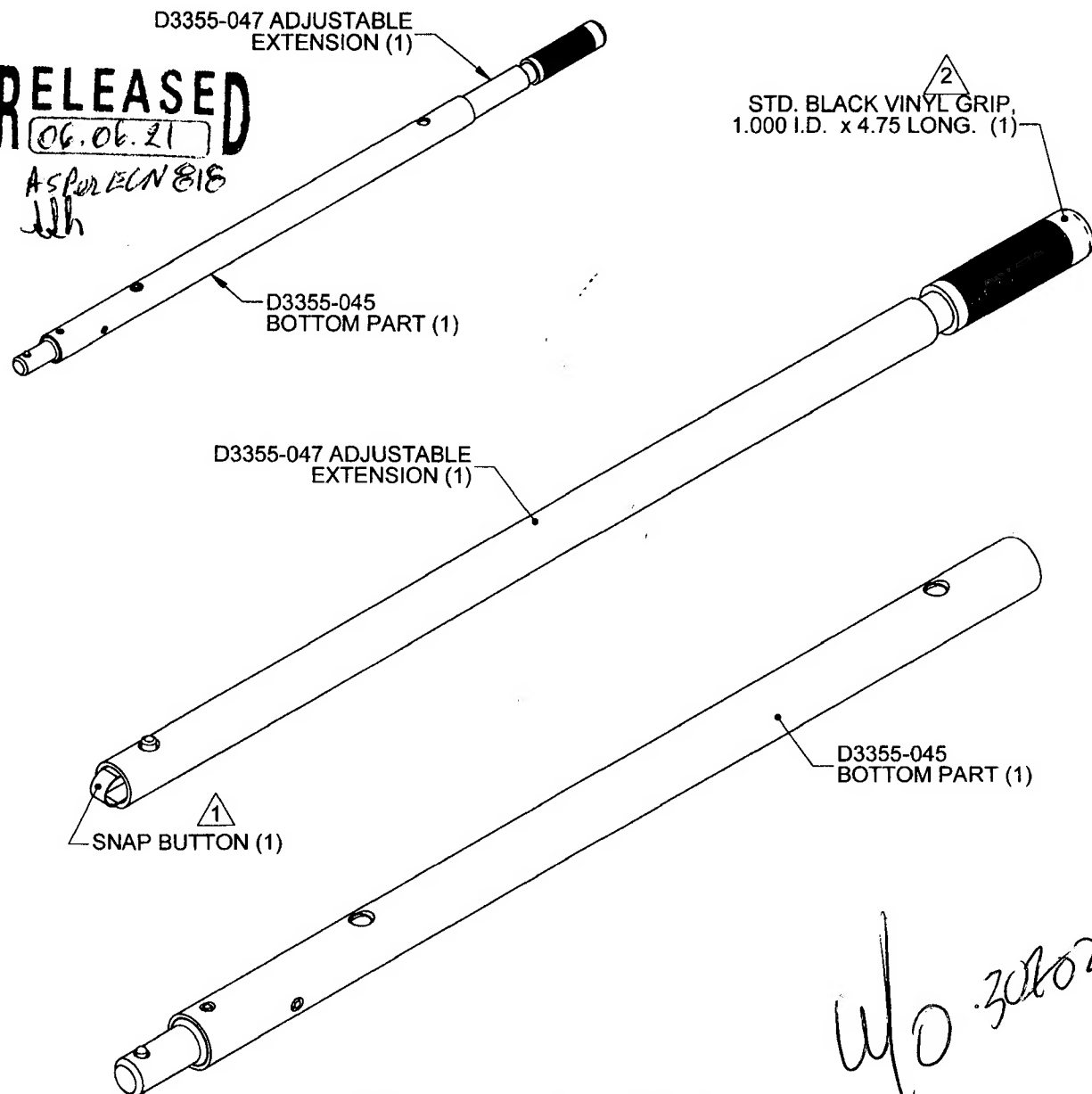
NOTE: Date & initial all entries

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3355	REV. B SHEET 1 OF 6
DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	

RELEASED
06.06.21

AS PER ECN 818
[Signature]



D3355-041 HANDLE ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

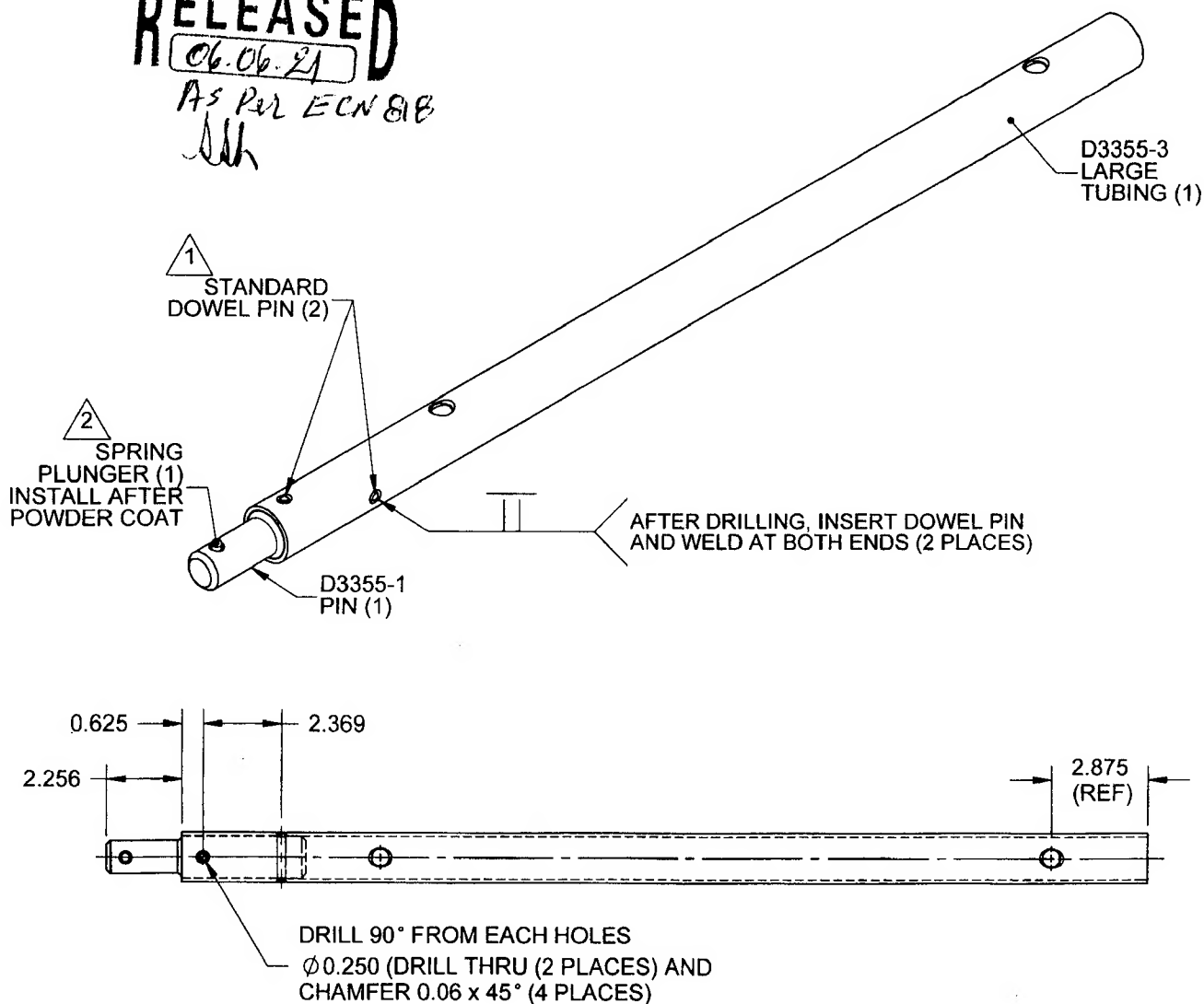
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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06.06.21

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[Signature]



D3355-045 BOTTOM PART

NOTES:

- 1) STEEL STANDARD GROUND DOWEL PIN, $\phi 0.250 \times 1.50$ LONG $\triangle B$
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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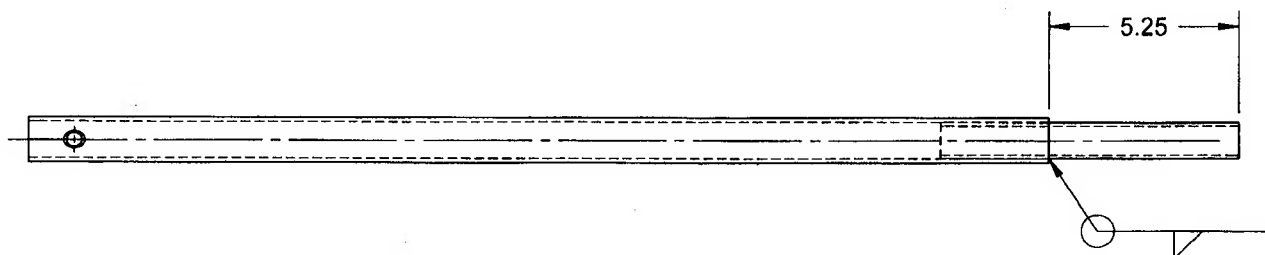
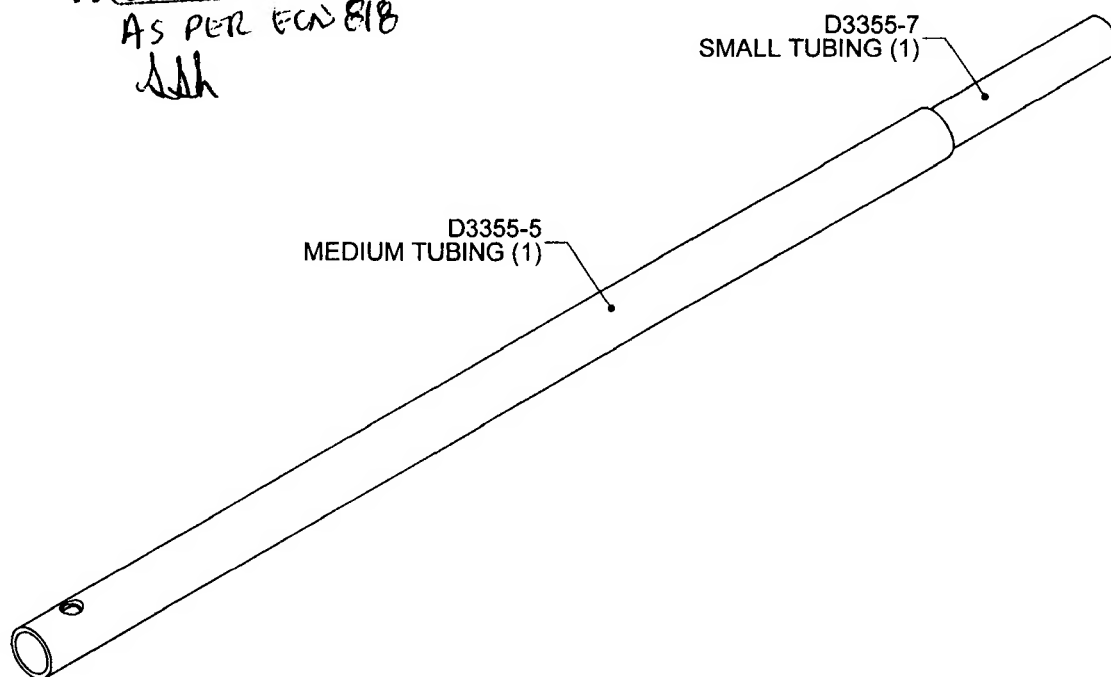


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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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06.06.21

AS PER ECN 818

[Signature]



D3355-047 ADJUSTABLE EXTENSION

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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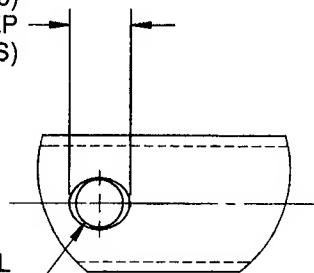


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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:6

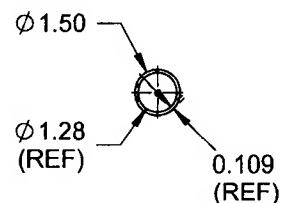
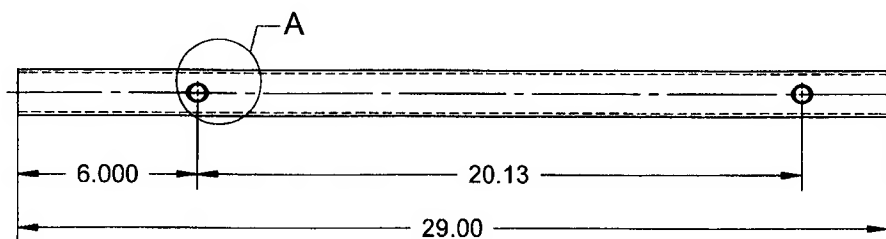
RELEASED
06.06.21
AS PER ECN 818 *[Signature]*

CHAMFER $\phi 0.687$ (11/16)
x 45°, 0.060 DEEP
(2 PLACES)

$\phi 0.531$ (17/32) DRILL
THRU (2 PLACES)



DETAIL A
SCALE 1 : 2



D3355-3 LARGE TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

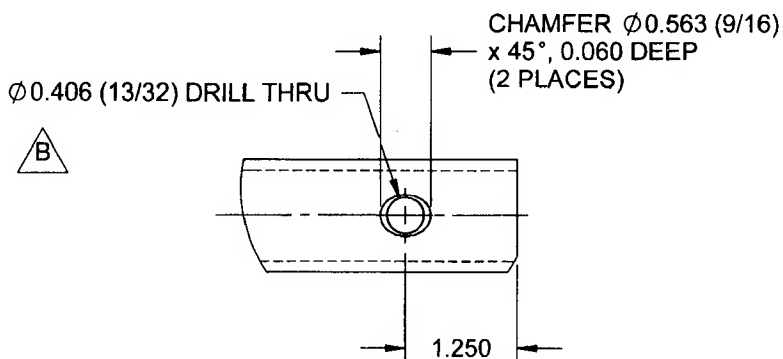
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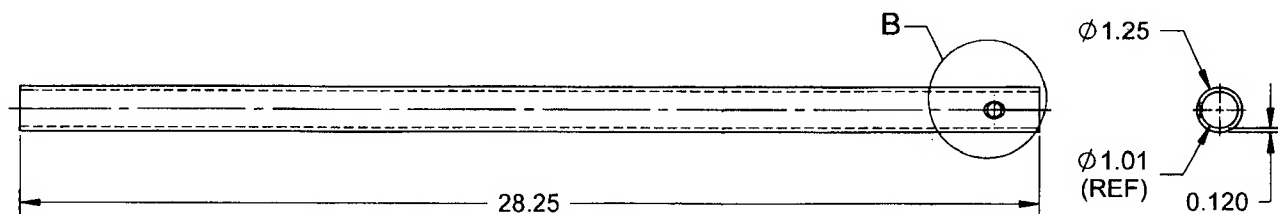


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DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:5

RELEASED
[06.06.21]
AS PER ECN 818
[Signature]



DETAIL B
SCALE 1 : 2



D3355-5 MEDIUM TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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